


Date: Wednesday, 4/4/2007 8:58:53 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE 412	
Job Number : 31596		
Estimate Number : 12783		
P.O. Number :	Part Number : D412664145	
This Issue : 4/4/2007 S.O. No. :	Drawing Number : D412-664-145 U/R	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : LANDING GEAR	Drawing Revision : U/R	
Previous Run : 31595	Material :	
Written By :	Due Date : 4/30/2007 Qty: 1 Um: Each	
Checked & Approved By : <u>07.04.04</u>		
Comment : Est Rev A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD412-664-105 CHG 001

N/A

2.0	D6019128	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6019-128 Crosstube B29964

Check OD = 2.7500", ID =

S.F 07/04/12

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Dwg D412-664-145

S.F 07/04/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/04/19

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 07/04/19

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jb7-4-19



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36419

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI-038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D212-664-201 S/N B31360
Qty. (1) P/N D058-676-101 S/N B30250
Qty. (2) P/N D206-667-101 S/N's B29101 & B28680
Qty. (3) P/N D412-664-145 S/N's B31396, B31594 & B31595

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Five (5) cross tubes PASSED inspection and two (2) cross tubes FAILED inspection (P/N D212-664-201 S/N B31360 & P/N D058-676-101 S/N B30250).

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE May 31, 2007

INSPECTION STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3825

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

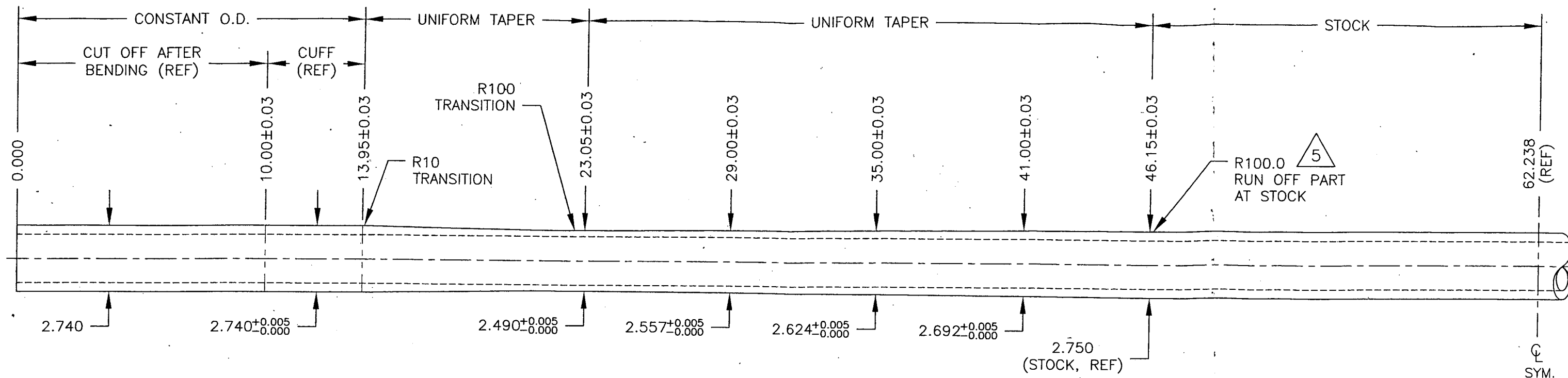
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PST

INVOICE NO.

TOTAL \$

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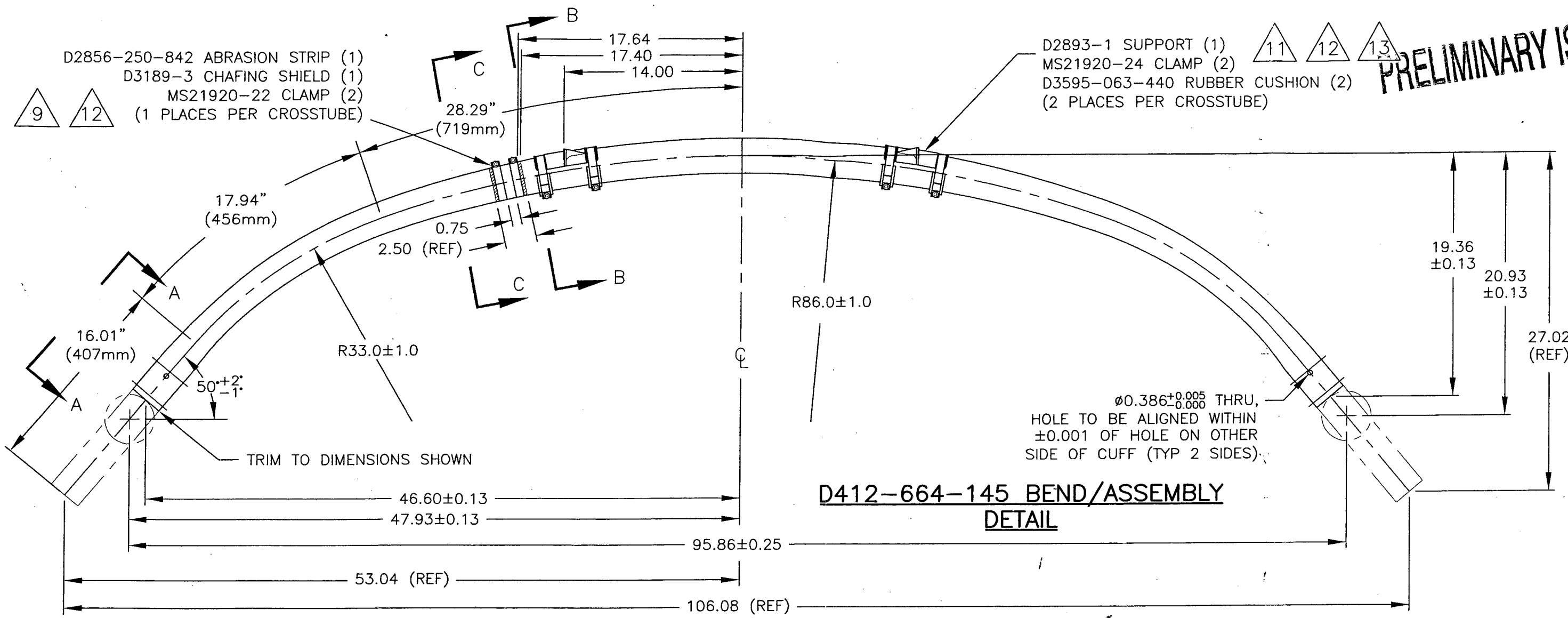
D412-664-145 MACHINING DETAIL

PRELIMINARY ISSUE

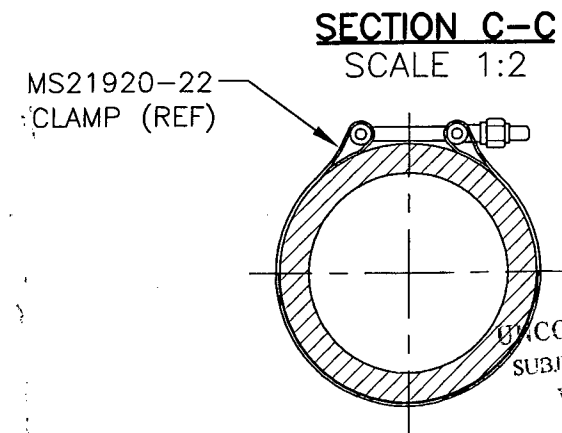
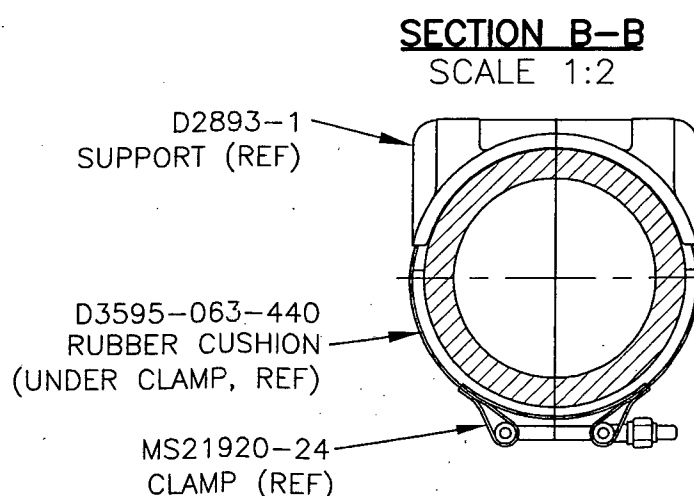
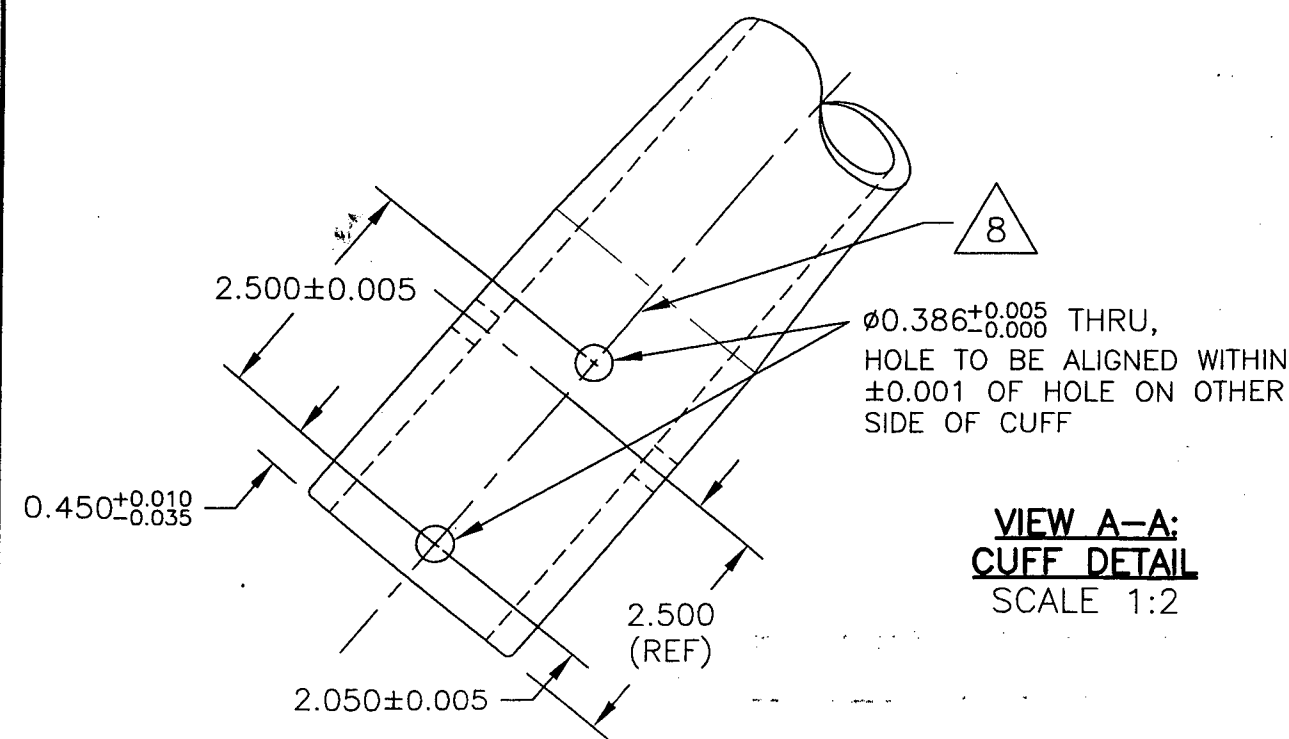
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DATE <u>07.03.01</u>		TITLE CROSSTUBE (412 LOW-NARROW FWD)		SCALE 1:4	

PRELIMINARY ISSUE



**D412-664-145 BEND/ASSEMBLY
DETAIL**



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DATE 07.03.01		TITLE CROSSTUBE (412 LOW-NARROW FWD)		SCALE 1:8	

